

011996



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C3-K

Job Sheet 200765



Part No: C3-K

Job Qty: 1 pcs

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity - Keeperless



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/17/19

Job Tracking No:

Due Date: 11/4/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19302

Note: DWG C3-K Rev 3 IPP Rev A 18.03.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	External Load - 1	1 pcs	11/4/19		0.00	1.00	External Load - 1		Mach 2019-9-24
							External Load - 2		
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	11/4/19		0.00	1.00	External Load - 1 - B4B		Mach 2019-10-28 AP 2019/10/29
							External Load - 2 - B4B		
							External Load - 3 - B4B		
110	QC 5	1 pcs	11/4/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-2 - Stock - B4B	1 pcs	11/4/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



Container No: S215153



Part: C3 - K

Job No: 200765

Serial No/Batch: S215153

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 09/19/19

DSS

OCT 29 2019

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	11/4/19	0.00 0.00	DC - 1 - B4B	DAS
				DC - 2 - B4B	21
140 QC 21 - SA	1 pcs	11/4/19	0.00 0.00	QC 21 - SA - 21	9-89 OCT 30 2010
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 OCT 30 2010

Part Op 95 - Issue S/N

Descriptions: 100 - (Small Fab)1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 2. 2-

ASSEMBLE AS PER DWG

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)Identify and Stock

135 - (Document Control)Photocopy blue file OM & OOPM-C3 Rev 4

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	95-External Load - 1	5110 495
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	100-External Load - 2 - B4B	5126 989
2595K22	Heat Shrink Tube	1 pcs (1 ea)	100-External Load - 2 - B4B	5073047
32446	Crimp Terminal	2 Ea (2 ea)	100-External Load - 2 - B4B	5074909
8183K6	Wire Guide/Grip	1 Ea (1 ea)	100-External Load - 2 - B4B	5029 491
AN4-16A	Bolt	3 Ea (3 ea)	100-External Load - 2 - B4B	5196064-2

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AN4-17A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5157429-3
AN6-15A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5068641
C2-4-1	Manual Release Knob	1 pcs (1 ea)	100-External Load - 2 - B4B	5190045
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5068051
C2-11-2	Locating Pin	2 Ea (2 ea)	100-External Load - 2 - B4B	5061528
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-External Load - 2 - B4B	5177832
C2-3-10	Latch Shaft	1 pcs (1 ea)	100-External Load - 2 - B4B	5180410
C2-3-11	Actuator	1 pcs (1 ea)	100-External Load - 2 - B4B	5174393
C2-3-2	Latch Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5173563
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-External Load - 2 - B4B	5168898
C2-3-3	Latch Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	5116487
C2-3-3-1	Latch Roller DU Bearing	1 pcs (1 ea)	100-External Load - 2 - B4B	5182513
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	100-External Load - 2 - B4B	5199313
C2-3-6	Latch	1 pcs (1 ea)	100-External Load - 2 - B4B	5148221
C2-3-8	Actuator Shaft Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5196195
C2-5-1	Actuator Stop	1 Ea (1 ea)	100-External Load - 2 - B4B	5072964
C3-10-2	Lock Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	5197483
C3-11-1	Side Plate - Solenoid C3-Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5182333
C3-12-1	Lock Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5193685
C3-12-2	Lock Shaft - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5080193
C3-12-3	Lock - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5190711
C3-12-4	Lock Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	5125633
C3-12-5	Lock Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	5188182
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	100-External Load - 2 - B4B	5206297
C3-13-1	Keeper Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5206235
C3-13-4-2	Keeperless Adapter	1 pcs (1 ea)	100-External Load - 2 - B4B	5129082
C3-2-1	Side Plate C-3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5175253
C3-3-4	Link Pin	2 pcs (2 ea)	100-External Load - 2 - B4B	5228778
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	100-External Load - 2 - B4B	5214930
C3-3-7	Link	1 pcs (1 ea)	100-External Load - 2 - B4B	5048390
C3-3-9	Actuator Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	5128955
C3-4-1	Load Beam Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	5192917
C3-4-4KA	Keeperless Load Beam Assembly - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5059062
C3-7-1	Load Beam Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	5208794
C3-7-2	Lock Bumper	2 pcs (2 ea)	100-External Load - 2 - B4B	5214422
C3-8-2	Solenoid	1 pcs (1 ea)	100-External Load - 2 - B4B	5210004
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	100-External Load - 2 - B4B	5213024
C3-8-5	Solenoid Cover	1 pcs (1 ea)	100-External Load - 2 - B4B	5204110
C3-9-1	Clock Spring Cover - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	5116295
C3-9-2	Spring, Clock	1 pcs (1 ea)	100-External Load - 2 - B4B	5089524
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-External Load - 2 - B4B	5192574
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 ft (1 ea)	100-External Load - 2 - B4B	5075144
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-External Load - 2 - B4B	5203176
MS21083-N3	Nut	2 Ea (2 ea)	100-External Load - 2 - B4B	5142051
MS21083N6	Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	5192157
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	5183289
NAS1149F0332P	Washer (AN960-10L)	2 Ea (2 ea)	100-External Load - 2 - B4B	5103666
NAS1149F0363P	Washer (AN960-10)	1 Ea (1 ea)	100-External Load - 2 - B4B	5075330-3
NAS1149F0463P	Washer (AN960-416)	8 Ea (8 ea)	100-External Load - 2 - B4B	5201801
NAS1149F0632P	Washer (AN960-616L)	2 Ea (2 ea)	100-External Load - 2 - B4B	5134711

Leatite 842 (5186572)

Leatite 620 (5194792)

Soft-T-ye (M138973)

Aeroshell grease NO.7 (M138724)

511243

5048297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-External Load - 1	188-FPSS-1032-1/4	2	101	0
100-External Load - 2 - B4B	188-FSCS-832-5/8	4	197	0
	2595K22	1	26	0
	32446	2	596	0
	8183K6	1	22	0
	AN4-16A	3	352	0
	AN4-17A	1	253	0
	AN6-15A	1	32	0
	C2-1-1	1	9	0
	C2-10-1	1	65	0
	C2-11-2	2	38	0
	C2-3-1	2	64	0
	C2-3-10	1	11	0
	C2-3-11	1	19	0
	C2-3-2	1	22	0
	C2-3-2-1	2	28	0
	C2-3-3	1	43	0
	C2-3-3-1	1	26	0
	C2-3-5	2	101	0
	C2-3-6	1	3	0
	C2-3-8	2	49	0
	C2-5-1	1	3	0
	C3-10-2	1	26	0
	C3-11-1	1	11	0
	C3-12-1	2	40	0
	C3-12-2	1	17	0
	C3-12-3	1	21	0
	C3-12-4	1	28	0
	C3-12-5	1	30	0
	C3-12-6	2	102	0
	C3-13-1	2	66	0
	C3-13-4-2	1	10	0
	C3-2-1	1	13	0
	C3-3-4	2	2	0
	C3-3-4-1	4	118	0
	C3-3-7	1	12	0
	C3-3-9	1	31	0
	C3-4-1	2	39	0
	C3-4-4KA	1	8	0
	C3-7-1	1	36	0
	C3-7-2	2	24	0
	C3-8-2	1	17	0
	C3-8-4	1	53	0
	C3-8-5	1	21	0
	C3-9-1	1	12	0
	C3-9-2	1	30	0
	EL-PLUG-M	1	14	0
	M27500-16TG2T14	1	40	0
	MS21044N4	4	69	0
	MS21083-N3	2	44	0
	MS21083N6	1	48	0
	MS35266-63	1	22	0
	NAS1149F0332P	2	1,756	0
	NAS1149F0363P	1	352	0
	NAS1149F0463P	8	496	0
	NAS1149F0632P	2	312	0

Part Specifications

Specifications could not be found.

****MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!****

NEW SOLENOID (152951-001)

Work Order 200765

Customer Order 19302

Serial Number 5215153

Date 2019-10-29

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	<u>Pass</u>
10	1,500	Electircal, 25 volts	No "hang ups" permitted	N/A	<u>Pass</u>
2	3,000	Electircal, 22 volts	Current shall not exceed 12.8 A	<u>9.3</u> A	<u>Pass</u>
2	2,500	Electircal, 22 volts	Current shall not exceed 12.8 A	<u>9.3</u> A	<u>Pass</u>
2	2,000	Electircal, 22 volts	Current shall not exceed 12.8 A	<u>9.2</u> A	<u>Pass</u>
2	1,500	Electircal, 22 volts	Current shall not exceed 12.8 A	<u>9.1</u> A	<u>Pass</u>
2	500	Electircal, 22 volts	Current shall not exceed 12.8 A	<u>9.0</u> A	<u>Pass</u>
1	3,000	Electircal, 20 volts	Current shall not exceed 11.6 A	<u>8.4</u> A	<u>Pass</u>
1	3,000	Electircal, 28 volts	Current shall not exceed 16.2 A	<u>7.8</u> A	<u>Pass</u>
1	3,000	Manual		N/A	<u>Pass</u>
1	3,000	Impact Test	Impact shackle 10x , shall not release	N/A	<u>Pass</u>
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω	<u>2.0</u> Ω	<u>Pass</u>
1	N/A	Electircal Continuity	Across both wires	N/A	<u>Pass</u>

Test Conducted By: Michel Lalonde

Technician

Submit

Signature: Sylvie Boncher
QC 5 Small FAB / QA